

# Work Order ID 91475

October-10-12 2:47:43 PM

**\*91475\***

Page 1

Item ID: D4543-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Outer, RH

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12-10-10 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4543	A								
100		0.00							
<b>*100*</b>									
Waterjet		0.00				15	0		Jm 12-11-06
FLOW CNC Waterjet									
60061-032									
	Memo								
	1- Cut as per dwg								
	Prog rev: <u>15</u>								
	Dwg rev: <u>15</u>								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC		0.00				15	0		Jm 12-11-06
Quality Control	Memo								

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**\*15\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				15			
130 <b>*130*</b> Small Fab Small Fab	FORM ON BEAD ROLLER (DT9787) Memo	0.00  0.00				15			FF 12-11-15
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				15			

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Page 3

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Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Outer, RH

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

15 16 12/11/20

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

QAS  
15  
12/11/20

15

170

Identify as per dwg & Stock Location: 5T128

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

15

12/11/20 JB

**Work Order ID 91475**

October-10-12 2:47:43 PM

**\*91475\***

Page 4

Item ID: D4543-2

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Outer, RH

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/11/22 *[Signature]**mf*

12-11-21

# Picklist Print

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Page 1

Work Order ID: 91475

\*91475\*

Parent Item: D4543-2

\*D4543-2\*

Parent Item Name: Retainer, Outer, RH

Start Date: 10/10/2012

Required Date: 10/12/2012

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP revA 12.01.12 New Issue EC verified by:DD  
12.02.24 as per dwg reva DD verf:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	700.0600	0.611	<del>9.647368</del>			
										**	9.7		
*M6061T6S 032*													
6061-T6 Sheet 0.032"													

In rev -06

## Location

## Loc Qty

## Loc Code

MAT021

700.06

121099

85.97

122256

40.89

122737

30.1

123097

91.1

123135

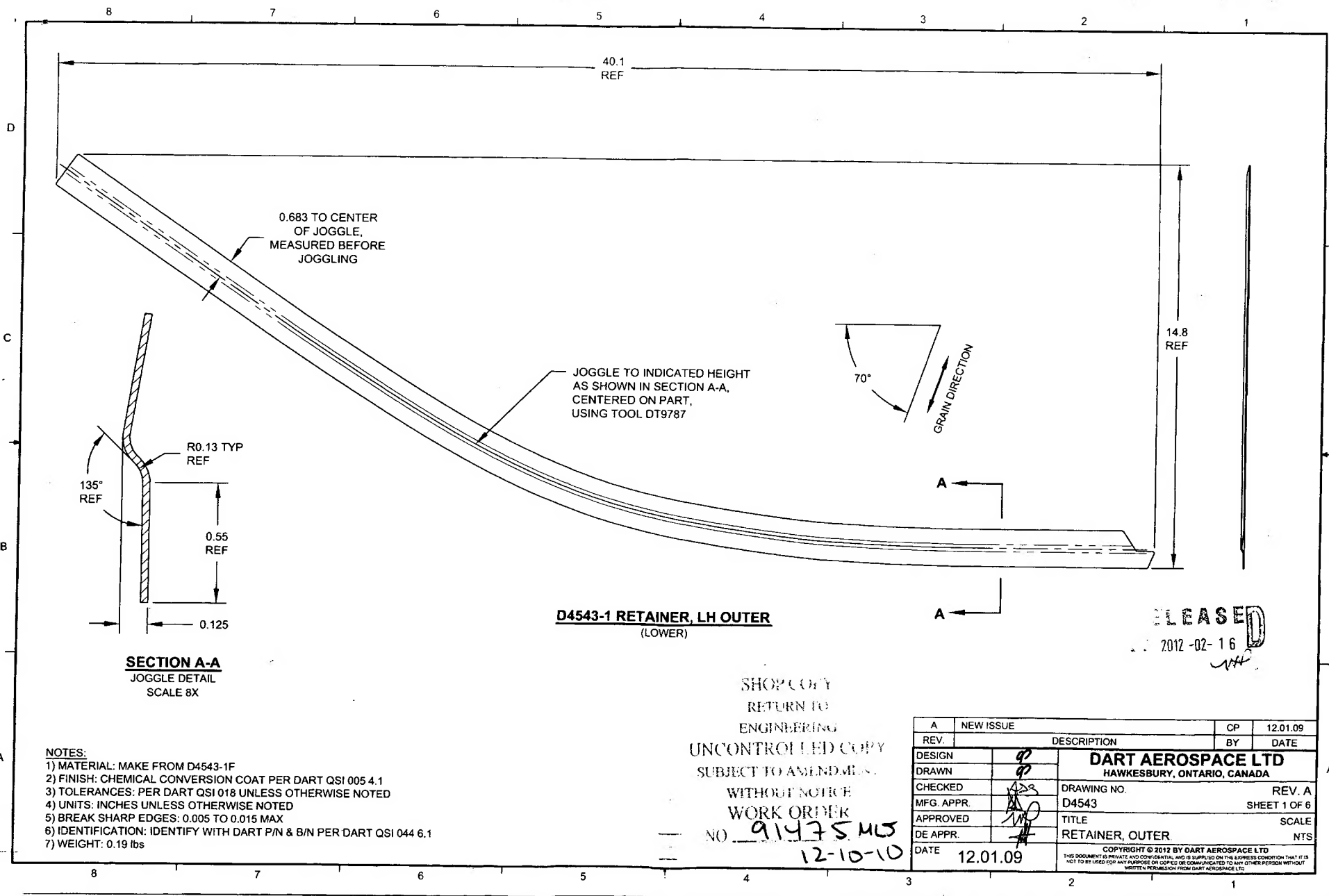
96

123137

356

123137





**SECTION A-A**  
JOGGLE DETAIL  
SCALE 8X

**D4543-1 RETAINER, LH OUTER**  
(LOWER)

- NOTES:**
- 1) MATERIAL: MAKE FROM D4543-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
  - 7) WEIGHT: 0.19 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENTS

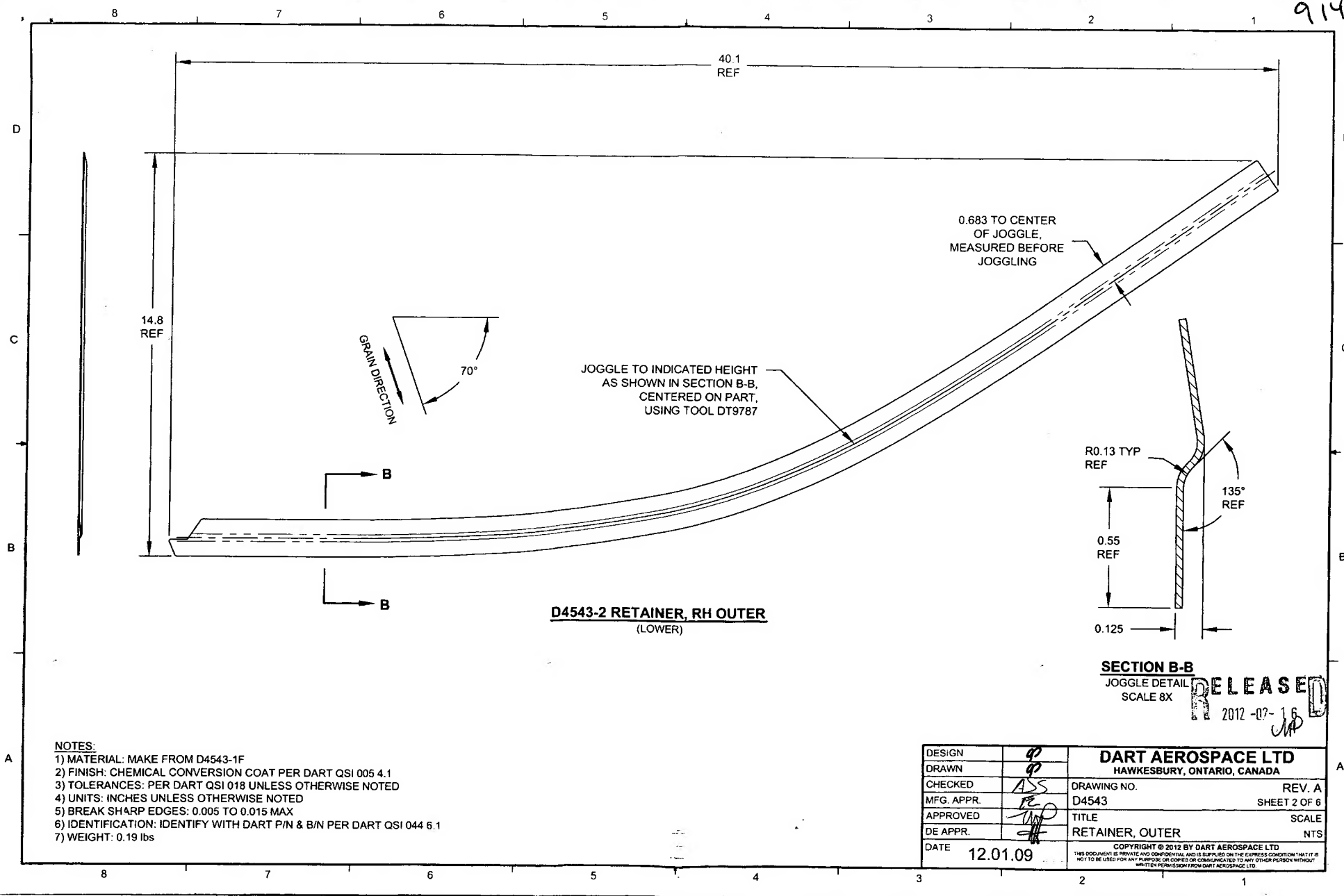
WITHOUT NOTICE  
WORK ORDER

NO **91475 ML3**  
**12-10-10**

**PLEASED**  
2012-02-16

A		NEW ISSUE		CP	12.01.09
REV.		DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE		12.01.09		REV. A SHEET 1 OF 6 SCALE NTS	
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91475



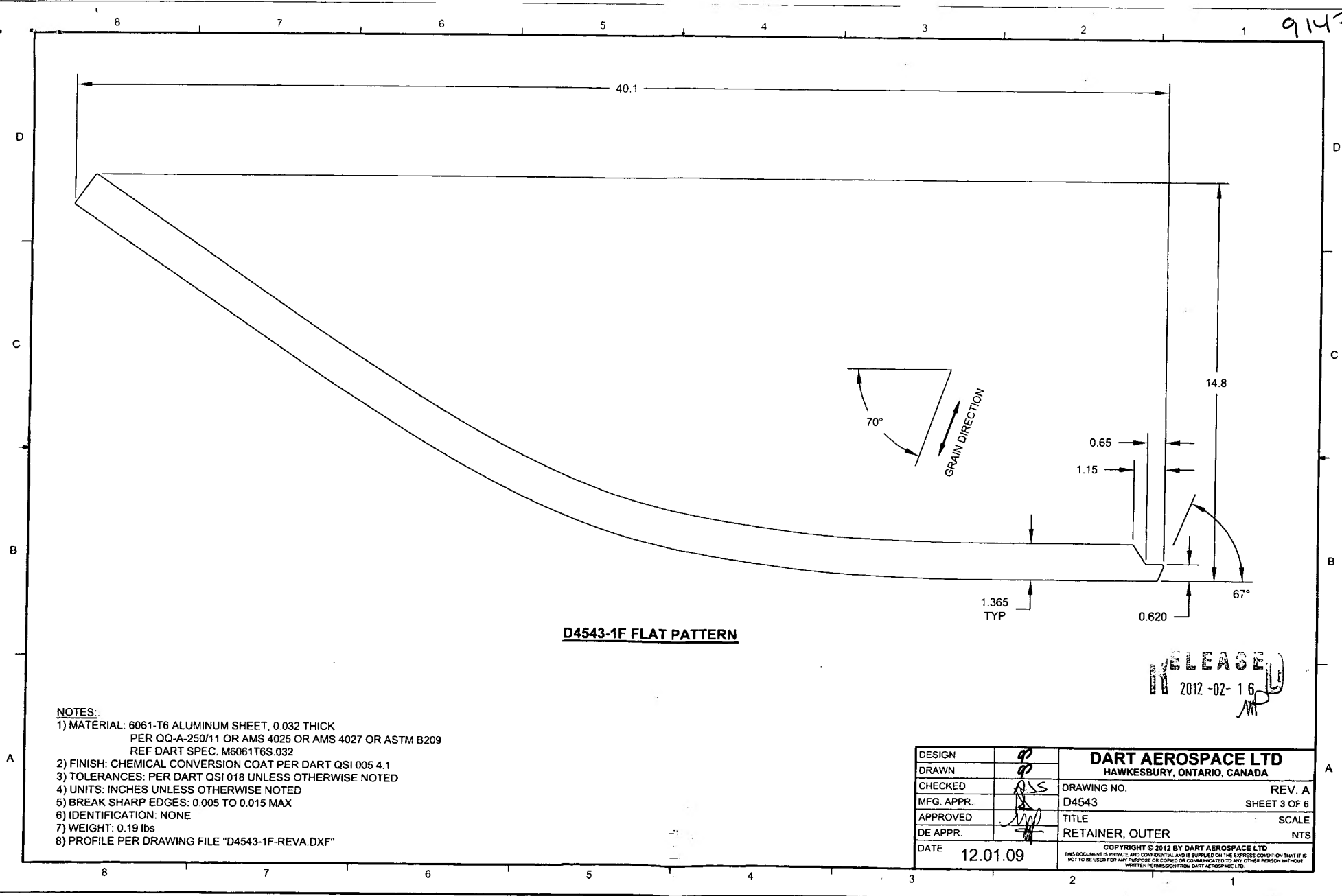
**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	FE	D4543	SHEET 2 OF 6
APPROVED	THP	TITLE	SCALE
DE APPR.	JH	RETAINER, OUTER	NTS
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**D4543-1F FLAT PATTERN**

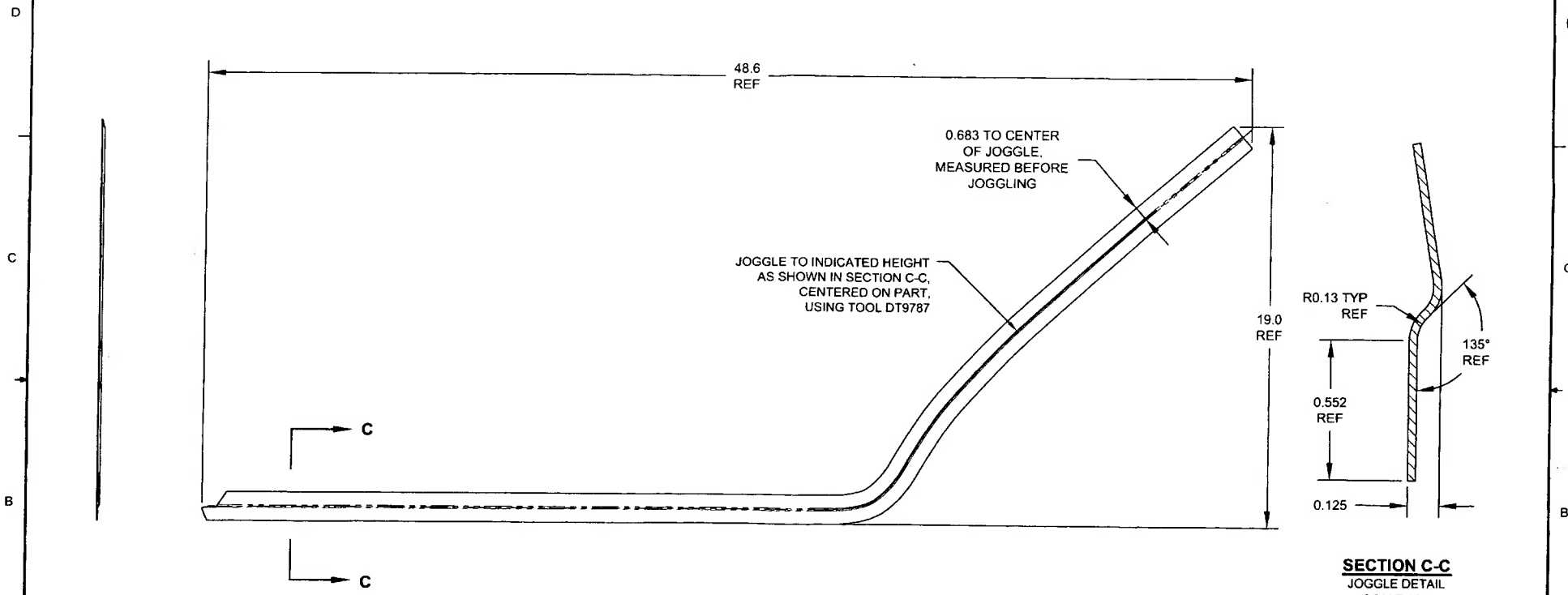
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DRAWING FILE "D4543-1F-REVA.DXF"

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2012-02-16

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, OUTER	NTS
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**D4543-3 RETAINER, LH OUTER**  
(SIDE/TOP)

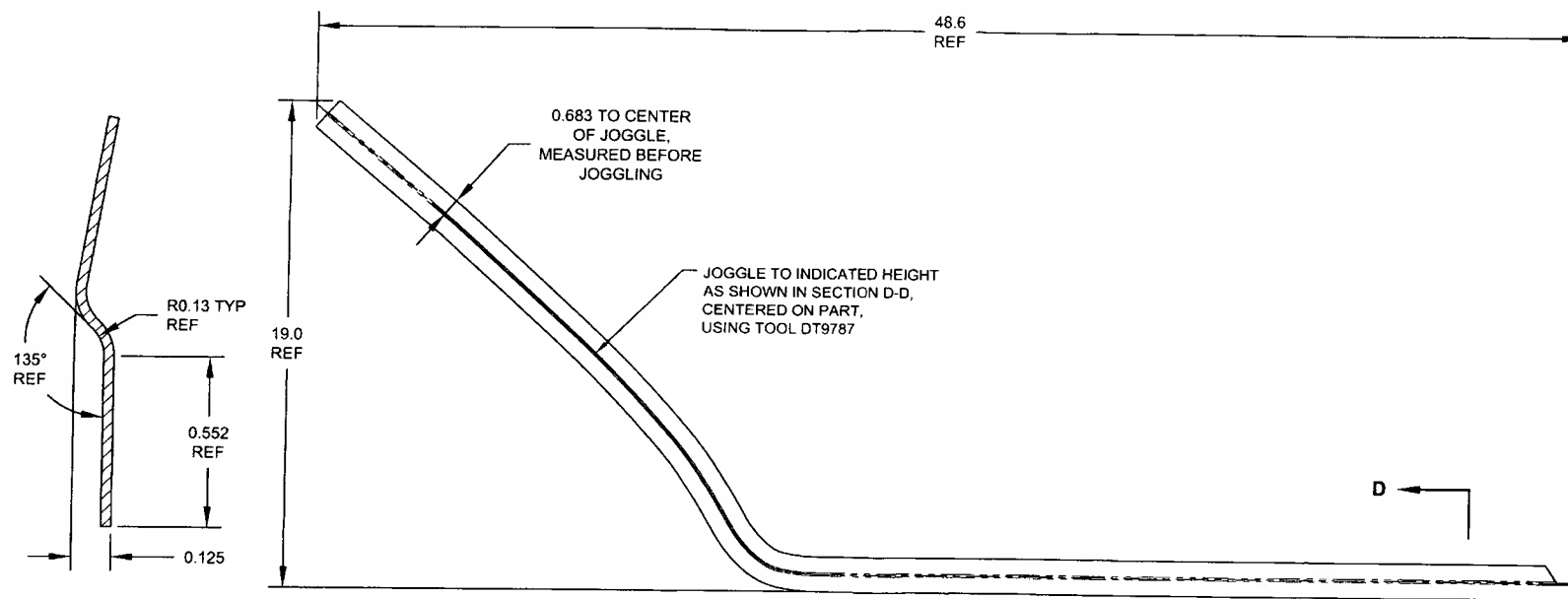
RELEASED  
2012-02-16

**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

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91475



**SECTION D-D**  
JOGGLE DETAIL  
SCALE 12X

**D4543-4 RETAINER, RH OUTER**  
(SIDE/TOP)

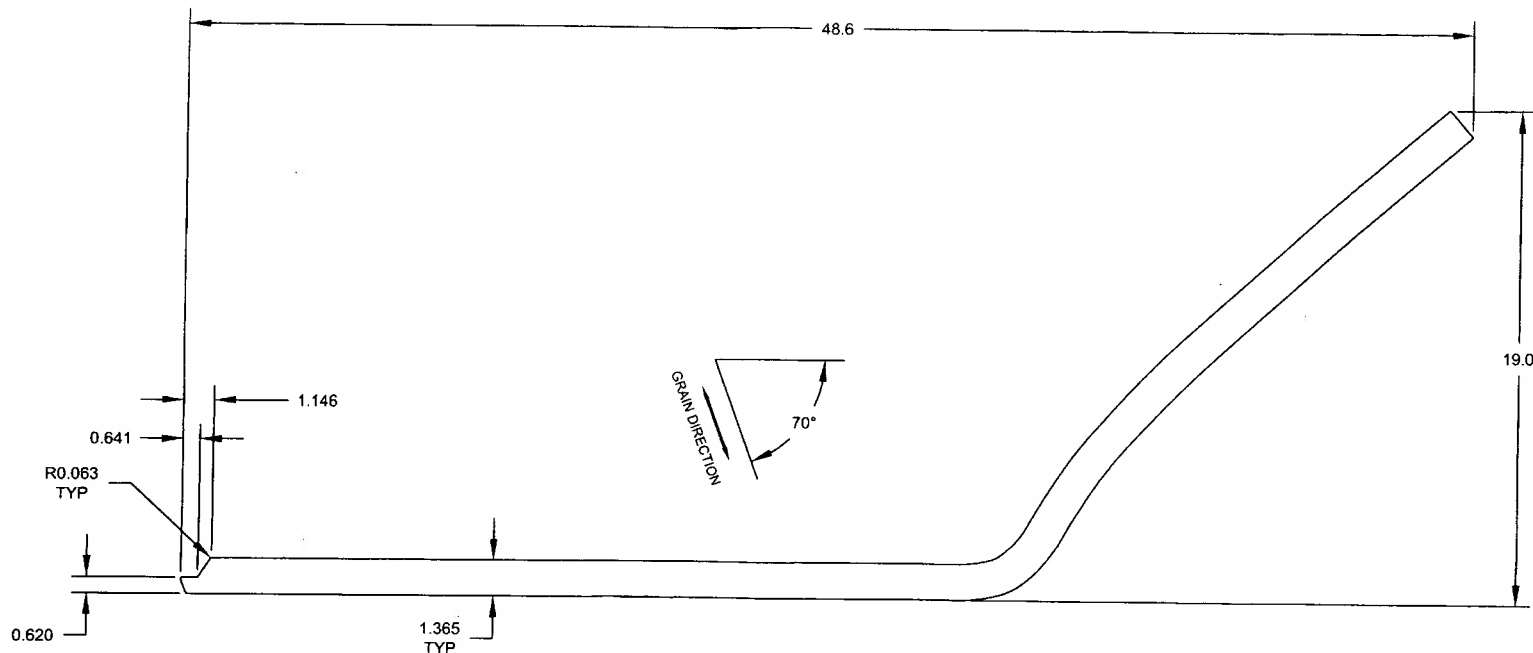
RELEASED  
2012-02-16

**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

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CHECKED	AYS	DRAWING NO.	REV. A
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APPROVED	<del>AYS</del>	TITLE	SCALE
DE APPR.	<del>#</del>	RETAINER, OUTER	NTS
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**D4543-3F FLAT PATTERN**

RELEASED  
2012-02-16

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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVA.DXF"

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DRAWN	<i>P</i>	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 6 OF 6
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